

# Work Order ID 62059-1

November 16, 2010 10:45:59 AM



Page 1

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 11/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*on 10/16/16*

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

*on 10/16/16*

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

*on 10/16/16*

Quality Control

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November 16, 2010 10:45:59 AM



Page 2

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Item Name: Saddle LH Out, 206

Start Date: 11/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

2L 10/11/17

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=> 2L 10/11/17

Memo

0.00

1 Ø

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

NA 115291

Memo

0.00

START TIME:

9:30

OVEN TEMPERATURE:

320 FINISH TIME:

10:00

1 BR 10-11-18



# Picklist Print

November 16, 2010 10:45:58 AM

Page 1

Work Order ID: 62059-1

Parent Item: D2938-1

Parent Item Name: Saddle LH Out, 206



Start Date: 11/16/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	4.0000	1	1			

Saddle Billet, 7075

Location

MAT042

61250

Loc Qty

4

4

Loc Code

*and 10/11/10*



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 62059-1
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.126					
B	0.100	0.140		.120					
C	0.100	0.140		.117					
D	0.210	0.230		.222					
E	1.245	1.255		1.256					
F	1.245	1.255		1.250					
G	2.495	2.505		2.506					
H	0.510	0.515		.500					
I	1.572	1.582		1.575					
J	2.495	2.505		2.498					
K	0.257	0.262		.260					
L	0.312	0.317		.315					
M	0.235	0.240		.236					
N	0.100	0.140		.113					
O	0.540	0.560		.549					
P	0.490	0.510		.510					
Q	3.715	3.725		3.718					
R	2.720	2.760		2.741					
S	0.240	0.270		.253					
T	0.100	0.180		.130					
U	1.625	1.635		1.628					
V	1.362	1.372		1.365					
W	0.316	0.321		.317					
X	1.250	1.270		1.258					
Y	1.565	1.585		1.572					
Z	0.178	0.198		.188					
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 10/11/17

Audited by: <i>[Signature]</i>
Date: 10/11/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

